1/19 1/2 +120

Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D4776-1

Job Sheet 194856

Part No: D4776-1
Part Name: Basket Strut Clevis
Part Weight: 0 lbs
Job Created: 5/9/19
Due Date: 6/26/19
Type: Stock

Job Qty: ~~5~~ ~~40~~ 56 pcs DAS 21 9-89

Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description:

Priority: Medium

Note: DWG D4776 REV.E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Doosan - 1	5 pcs		6/26/19	0.54	2.66	Doosan - 1		DAS 5 9-89
105	QC 2	5 pcs		6/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

DART AEROSPACE

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Container No: S187143

Part: D4776-1
Job No: 194856
Serial No/Batch: S187143
Revision: E
Inspector:
Exp Date:
Instructions: Various STC's

Date: 06/04/19

DAS 5 9-89

QC 2 25

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
111	**QC 8**	5 pcs	6/26/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	DMR 19/06/05
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
112	**Handfinish - 1-1 Chemical-B4B**	5 pcs	6/26/19	0.00 0.14	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	JUN 06 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 -	

					B4B	
113	**QC 7**	5 pcs	6/26/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	BL 19-6-6.
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
115	**Powdercoat - 1 White GI(A)-B4B**	5 pcs	6/26/19	0.00 0.06	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	BEBA-06-06.
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
116	**QC 3**	5 pcs	6/26/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	DAS
					QC 3 - 40	JUN 07 2019 40
					QC 3 - 19	9-89
					QC 3 - 43	
					QC 3 - 24	
130	**Packaging 3-1 - Stock - B4B**	5 pcs	6/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	ST 114 JUN 10 2019
					Packaging 3 - 5 - B4B	

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 **QC 21 - SA**	5 pcs	6/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS JUN 1 0 2019
				QC 21 - SA - 53	DAS 21 9-85

Part Op Descriptions:
100 - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: _____ & Dwg D4776 Rev: _____ 2 -Deburr per dwg D4776
105 - (QC2- Inspect parts off machine FAI/FAIB)
111 - (QC8- Inspect parts - second check)
112 - (Chemical Conversion Coat per QSI005 4.1)
113 - (QC7-Inspect Chemical Conversion Coat)
115 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME: 5/7/19 2:00 OVEN TEMPERATURE: 320 FINISH TIME: 2:30
116 - (QC3- Inspect Part Finish)
130 - (Identify as per dwg & Stock Location:_____)
140 - (QC21- Final Inspection - Work Order Release)

20FT

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	1.7050 ft ~~(.341 ea)~~ .355 ea	100-Doosan - 1	S172180

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R1.500	2	24	0

.12 FT SCRAP

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850		.88
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		.439
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		.388
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		.626
5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720		1.75
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470		3.5
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	45
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000		.024
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	Radius	R.06
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	.197
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	.262
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	Radius	R.41
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100		1.13
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178		.189
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160		.187
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470		.503
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740		.7500
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	.401
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	Radius	R.125
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750		.7535
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130		.158
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	45°

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong
☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance
☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing
☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing
☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread
☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up

Other/Details: